



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571

Job Sheet 174051



Part No: D2571

Job Qty: 15 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Due Date: 3/30/18

Created By: Michelle Gagnon-Donovan

Type: **SOLD**

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	15 Ea	3/28/18	3/28/18	0.00	0.00	Start Up Machining		SBZ 18/06/22
100	CNC Vertical Machining	15 pcs	3/29/18	3/29/18	0.57	24.19	HAAS 1		SBZ 18/06/01
110	Mill Conv	15 pcs	3/29/18	3/29/18	0.00	2.31	Mill Conv 1		SBZ 18/06/01
120	QC	15 pcs	3/29/18	3/29/18	0.00	0.00	QC2		SBZ 18/06/01
130	QC	15 pcs	3/29/18	3/29/18	0.00	0.00	QC8		SBZ 18-06-02
140	HandFinish	15 pcs	3/29/18	3/29/18	0.00	0.50	HandFinish1		SA 18-06-06
150	Powdercoat	15 pcs	3/30/18	3/30/18	0.00	0.60	Powdercoat1		SA 18-06-07
160	QC	15 pcs	3/30/18	3/30/18	0.00	0.00	QC3		SA 18-06-07
170	Packaging	15 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3		SA 18-06-07
180	QC21-SA	15 Ea	3/30/18	3/30/18	0.00	0.00	QC21		SA 18-06-07

Part Op 100 - Program Batch No. 5069074 Double check by: SA 1-Machine Step No 1 per Folio FA051 and inspect per SA
 Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
 Step No 3 per Folio FA051 and inspect
 110 - Machine keyway as per dwg D2571 & D2572
 120 - Inspect on CMM as per folio CMMA022.
 150 - START TIME: 8.15 FINISH TIME: 8.45. OUT: 320° M 134839.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	15 Ea (1 ea)	90-Start up Operation	

5069074 → 5072784

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	15	11	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010	3.505		

Plex 3/9/18 12:49 PM Dart.Gagnon.Michelle



Container No: S072785



Part: D2571

Job No: 174051

Serial No/Batch: S072785

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/18

			- 0.000	3.495
4	Saddle, Fwd Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Fwd Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000

Plex 3/9/18 12:49 PM Dart.Gagnon.Michelle

3/9/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

36	Saddle, Fwd Outboard	0.023Inches	+ 0.020	0.043
			- 0.000	0.023

Plex 3/9/18 12:49 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order: 174051
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.008	8.008	8.008		
F	0.490	0.510		0.501	0.501	0.502	0.497		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.569	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.134	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.253	0.254	0.253	0.253		
S	0.115	0.135		0.120	0.128	0.125	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.960	2.962	2.960		
V	0.230	0.250		0.245	0.245	0.247	0.245		
W	0.115	0.135		0.123	0.123	0.125	0.123		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.255	0.255	0.255		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.250	0.255	0.255	0.255		
AH	0.240	0.260		0.252	0.250	0.252	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBC	DAS
Date: 18/5/27	57
	9-89

Audited by: A.e
Date: 18-06-02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 17405/	
Description: Saddle, Fwd Outboard		Part Number: D2571	
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	62	73	84		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.008	8.012	8.010	8.000		
F	0.490	0.510		0.502	0.510	0.5055	501		
G	0.257	0.262		257	257	257	257		
H	0.375	0.380		375	375	375	375		
I	0.490	0.510		500	500	505	500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		568	568	0.577	567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		130	128	0.135	131		
Q	0.115	0.135		125	125	126	126		
R	0.240	0.260		253	253	253	253		
S	0.115	0.135		130	125	0.136	130		
T	0.178	0.198		188	188	188	188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		245	245	0.244	241		
W	0.115	0.135		123	121	0.122	125		
X	0.308	0.313		312	312	0.311	311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.363	363		
AA	0.470	0.530		500	500	500	500		
AB	0.615	0.635		624	631	630	628		
AC	0.053	0.073		063	063	0.063	0.063		
AD	0.240	0.260		250	250	0.253	253		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		130	128	0.135	120		
AG	0.240	0.280		260	260	255	260		
AH	0.240	0.260		250	250	0.257	252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBZ
Date: 18/5/27

Audited by: B.F.
Date: 18-06-02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.501	.500	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.133	.131	.133	.128		
Q	0.115	0.135		.126	.127	.125	.126		
R	0.240	0.260		.253	.255	.253	.253		
S	0.115	0.135		.130	.129	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.963	2.963	2.963		
V	0.230	0.250		.242	.242	.241	.242		
W	0.115	0.135		.121	.122	.124	.122		
X	0.308	0.313		.312	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.255	.253	.254	.254		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.123	.133	.127	.128		
AG	0.240	0.280		.255	.255	.255	.260		
AH	0.240	0.260		.251	.252	.250	.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SBL
Date:	18/5/27

Audited by:	B.A
Date:	18-06-02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 174051
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	4	By	Date
A	0.438	0.443		0.438	0.438	0.438			
B	1.745	1.755		1.750	1.750	1.750			
C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.750	1.750	1.750			
E	7.990	8.010		8.001	8.001	8.002			
F	0.490	0.510		0.498	0.499	0.500			
G	0.257	0.262		0.257	0.257	0.257			
H	0.375	0.380		0.375	0.375	0.375			
I	0.490	0.510		0.499	0.500	0.500			
J	1.174	1.184		1.179	1.179	1.179			
K	0.558	0.578		0.568	0.568	0.568			
L	1.174	1.184		1.179	1.179	1.179			
M	1.490	1.500		1.495	1.495	1.495			
N	2.495	2.505		2.500	2.500	2.50			
O	3.869	3.879		3.874	3.874	3.874			
P	0.115	0.135		0.133	0.133	0.131			
Q	0.115	0.135		0.126	0.126	0.126			
R	0.240	0.260		0.254	0.253	0.253			
S	0.115	0.135		0.130	0.125	0.128			
T	0.178	0.198		0.188	0.188	0.188			
U	2.940	2.980		2.962	2.962	2.962			
V	0.230	0.250		0.243	0.242	0.242			
W	0.115	0.135		0.123	0.123	0.122			
X	0.308	0.313		0.311	0.311	0.311			
Y	0.760	0.765		0.760	0.760	0.760			
Z	0.352	0.372		0.363	0.363	0.363			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.627	0.627	0.627			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.254	0.255	0.253			
AE	1.375	1.395		1.385	1.385	1.385			
AF	0.115	0.135		0.128	0.126	0.128			
AG	0.240	0.280		0.250	0.255	0.255			
AH	0.240	0.260		0.249	0.248	0.250			
AI	2.000	2.020		2.000	2.000	2.000			
AJ	0.023	0.043		0.033	0.033	0.033			
Accept/Reject									

Measured by: SBL
Date: 18/5/27

Audited by: A.F.
Date: 18-06-02

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	